

Date: Wednesday, 10/06/2009 10:34:08 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: RIB ASSY (INBOARD)
Job Number	: 48454		
Estimate Number	: 13661		
P.O. Number	:	Part Number	: D3827041
This Issue	: 10/06/2009 S.O. No. :	Drawing Number	: D3827 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 48100	Material	:
Written By	:	Due Date	: 16/06/2009 Qty: 6 Um: Each
Checked & Approved By	: <u>JLD 09.06.10</u>		
Comment	: Est Rev:A 08-12-01 new issue DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
✓ 1.0	D37591	Bushing
	Comment: Qty.: 3.0000 Each(s)/Unit Total : 18.0000 Each(s) Bushing batch: <u>B46536 X16</u> <u>B48331 X2</u> <u>SAD 09-06-19</u> (6)	
✓ 2.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
	Comment: Qty.: 8.4000 f(s)/Unit Total : 50.4000 f(s) 304 SQ Tube .75x.75x.065W batch: <u>M112051</u> <u>SAD 09-06-19</u> (6) <u>End Bar Scrap = 2 (sf)</u>	
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
	Comment: LARGE FABRICATION RESOURCE 1 ✓ 1- cut D3827-1 rib as per dwg D3827 ✓ 2- drill holes using DT9435 jig and open to finish size as per dwg D3827 ✓ 3- c'sink as per dwg ✓ 4- remove identification markings ✓ 5- deburr <u>SAD 09-06-23</u> (6)	
4.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP <u>SAD 09-06-23</u> (6)	
5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
	Comment: LARGE FABRICATION RESOURCE 1 1- weld bushing in rib as per dwg D3827 A/R ER316 S.S. Rod Batch: <u>M109213</u> <u>PL 09-06-24</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/06/2009 10:34:08 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIB ASSY (INBOARD)

Job Number: 48454

Part Number: D3827041

Job Number:



Seq. #:

Machine Or Operation:

Description :

2- grind weld flush

3- deburr if necessary

6.0

QC9

VISUAL WELDING INSPECTION

ADon/06/24 QC10



Comment: VISUAL WELDING INSPECTION

S 09/06/24 (6)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/06/24 (6)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

SAD 09-06-24 (6)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/24/9A

Job Completion



u 09.06.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3827-041	RIB ASSY (INBOARD)
2	3	D3759-1	BUSHING
3	1	D3827-1	RIB

D3827-041 RIB ASSY (INBOARD)

RELEASED
08/11/13

REV.	NEW ISSUE	DESCRIPTION	MB	08.09.23
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.09.23			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3827** REV. A

TITLE **RIB ASSY (INBOARD)** SCALE NTS

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- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 4.59 lbs

NO. **18854**
WORK ORDER
WITHOUT NOTICE
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8 7 6 5 4 3 2 1

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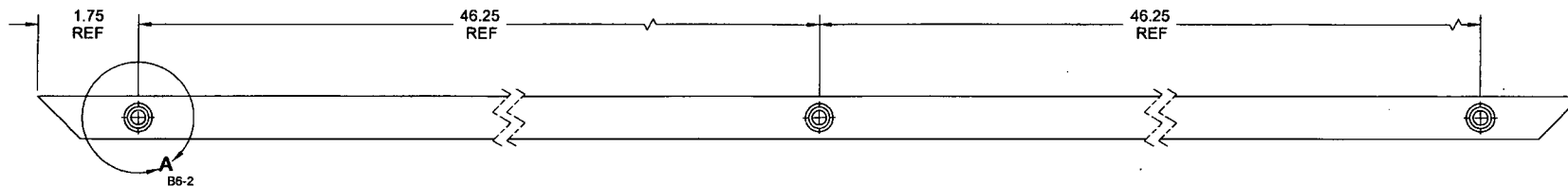
C

B

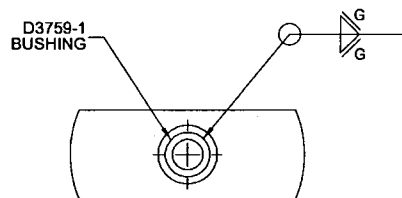
B

A

A



D3827-041 RIB ASSY (INBOARD)



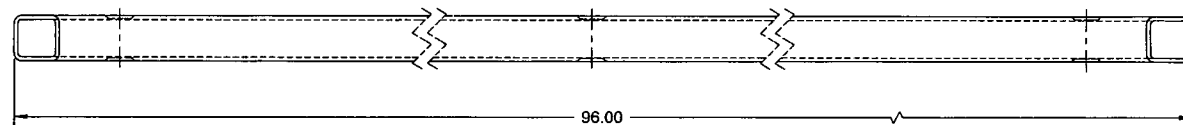
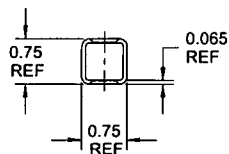
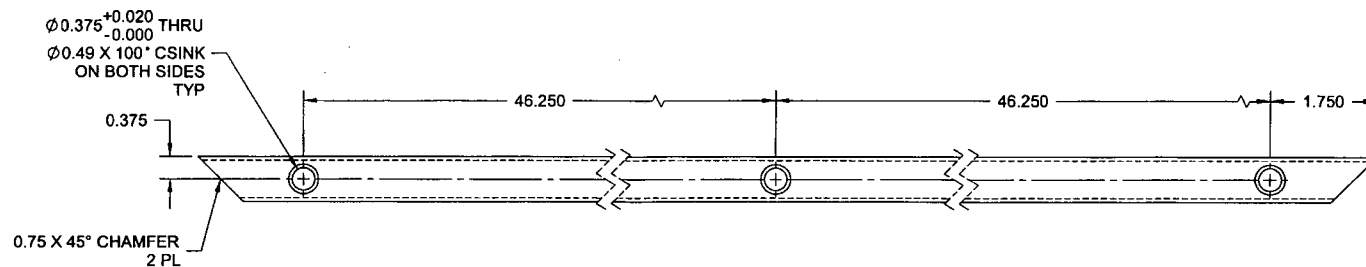
DETAIL A
SCALE 2X C7-2
3 PL

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WORK ORDER
NO. 48454

RELEASED
08/11/18 NWT

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO. D3827	REV. A
MFG. APPR.		TITLE	SHEET 2 OF 3
APPROVED		RIB ASSY (INBOARD)	SCALE
DE APPR.			NTS
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8 7 6 5 4 3 2 1



D3827-1 RIB

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WITHOUT NOTICE
WORK ORDER
NO. 22858

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.55 lbs

RELEASED
08/11/23

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3827	SHEET 3 OF 3
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